

Date: Thursday, 29/05/2008 11:04:55 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACER BUSHING
Job Number :	39560		
Estimate Number :	10826		
P.O. Number :		Part Number :	D23273
This Issue :	29/05/2008	Drawing Number :	D2327 REV D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	D
Previous Run :	37851	Material :	
Written By :		Due Date :	10/06/2008
Checked & Approved By :	JUD 08.5.29	Qty:	100 / 50 Um: Each
Comment :	Est. F 05.11.02 Removed 303 SS KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R0375	304 SS ROUND BAR
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Comment: Qty.: 0.1641 f(s)/Unit Total: 8.2058 f(s)

Inventory

Material: AISI 304 Round Bar Ø0.375"

(M304R0.375)

Batch: M107403 mmf 08/05/30

(111)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL

Turn per Folio FA232 and Dwg D2327

Deburr

J.F. / DTP / mmf 08/05/30

(111)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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J.F. / DTP / mmf 08/05/30

(111)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

RD 08/06/01

(111)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: Barclay Ref 3 (111)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 29/05/2008 11:04:55 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 39560

Part Number: D23273

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 0806-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39560
Description: Spacer Bushing		Part Number: D2327-3
Inspection Dwg: D2327	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

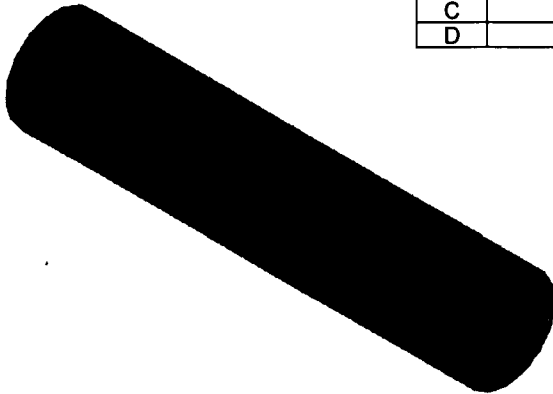
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	Ø.373	✓			
Ø0.257	+0.005/-0.000	Ø.259	✓			
1.750	+/-0.010	1.754	✓			

Measured by: MMR/DJP	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/05/30	Date: 08/05/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.01.28	Tolerance revised on Ø0.375	KJ/EC/DD	[Signature]

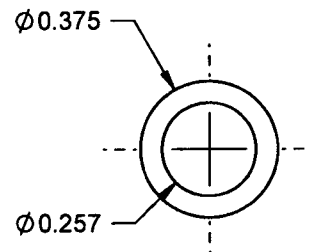
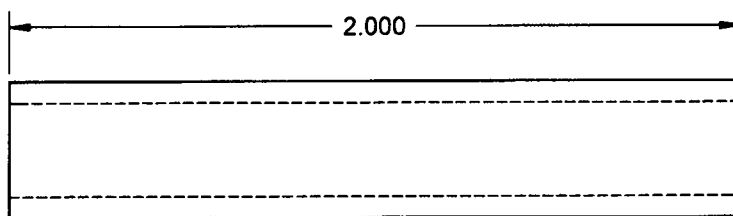


DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12	TITLE SPACER BUSHING		SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	

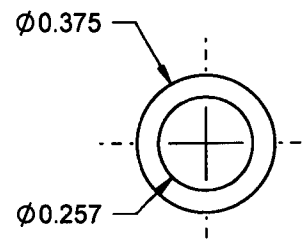
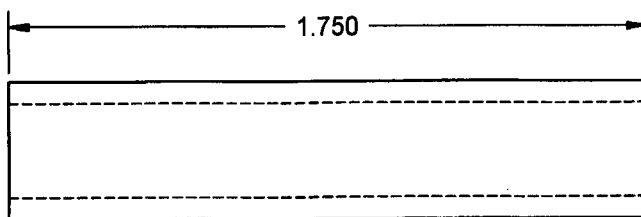


RELEASED

06.11.14



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39560

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